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D350-636-011
Job Sheet 192982



Part No: D350-636-011

Job Qty: 1 pcs

Part Name: Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/5/19

Job Tracking No: (return to stk (eng test))

Due Date: 4/9/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: D2750-041 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343
IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP
Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22
revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-
594 DD VERF:JLM IPP REV:S 18.11.09 AS PER ECN18-830 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	4/9/19		0.00	4.55	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
260	QC 4	1 pcs	4/9/19		0.00	0.00	QC 4 - 28		
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
270	Packaging 3-1 - Stock - B4B	1 pcs	4/9/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		
							Packaging 3 - 16 - B4B		

					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275	DC - 1 - B4B	1 pcs	4/9/19	0.00 0.00	DC - 1 - B4B	APR 11 2019
					DC - 2 - B4B	
280	QC 21 - FG	1 pcs	4/9/19	0.00 0.00	QC 21 - FG - 21	APR 11 2019 DAS 70 9-89
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op **110** - (Skidtubes) 1- Pick D2600-3 Bent 2- Debur FWD and AFT ends, remove bending marks. Scribe batch# inside AFT
 Descriptions: end per dwg D2750-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for 2nd side only DT8863B for first side (detail B) 4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 6-Open up holes of Detail A to 0.297" (total of 2 holes per side) 7-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: _____ 8-Grind welds flush as per Dwg D2750

260 - (QC4- 100% Inspect kits for completeness) *****ensure antiseize is on AN8C21A bolts*****

270 - (Identify as per dwg & Stock Location: _____) Package as per PPP D350-636-011 Location : FG108

275 - (Document Control) record fwd angle: _____ Photocopy blue file and type labels per PPP D350-636-011 CHG 008

280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D350-636-011	Skidtube LH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.	1 pcs (1 ea)	110-Skidtubes - 1	5171137

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D350-636-011	1	5	1

Allocated Container Detail

Qty	Container No	Location	Init
1	S076919	eng	_____

Part Specifications

Specifications could not be found.



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Container No: S171137



Part: D350-636-011

Job No: 192982

Serial No/Batch: S171137

Revision: H

Inspector:

Exp Date:

Instructions: FAA STC SR00646SE 18/10/17, TC STC SH99-7 Issue 2, EASA STC